



Dart Aerospace Ltd.
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Canada

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D2282-5

Job Sheet 189935



Part No: D2282-5

Job Qty: 150 pcs

Part Name: Tube



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/1/19

Job Tracking No:

Due Date: 3/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E IPP Rev:A Removed from 9 Digit 05-12-02 JLM IPPRev:B Now on Doosan Lathe 08-06-05 JLM
Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Doosan - 1	150 pcs	3/18/19	3/18/19	0.03	23.31	Doosan - 1	
120	QC 8	150 pcs	3/18/19	3/18/19	0.00	0.00	QC 8 - 12	
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 38	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
130	Packaging 3-1 - Stock - B4B	150 pcs	3/18/19	3/18/19	0.00	0.00	Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	
							Packaging 3 - 6 - B4B	
							Packaging 3 - 7 - B4B	
							Packaging 3 - 8 - B4B	
							Packaging 3 - 9 - B4B	



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Container No: S157266



Part: D2282-5

Job No: 189935

Serial No/Batch: S157266

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/27/19

				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	182
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
140 QC 21 - SA				150 pcs	3/18/19
				0.00	0.00
				QC 21 - SA - 21	DAG MAR 04 2019
				QC 21 - SA - 70	21
					9-00

Part Op 100 - (Doosan Lathe) 1-Turn as per Dwg D2282 and Folio FA189

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - (Identify as per dwg & Stock Location: _____) *****STOCK IN LARGE FAB*****

140 - (QC5- Inspect part completeness to step on W/O)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R0.750	304 SS Roundbar .750	27.0090 ft (18000 ea)	100-Doosan - 1	S12403

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M304R0.750	27	4	0

32.86

SCRAP 171

24 1/2"

48"

112 FT

+12 FX

72 FT

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Handle Tube	2.170Inches $\pm$ 0.030	2.200 2.140	2.168	
2	Handle Tube	0.063Inches $\pm$ 0.010	0.073 0.053	R.0625	Radius
3	Handle Tube	0.063Inches $\pm$ 0.010	0.073 0.053	.062	
4	Handle Tube	0.125Inches $\pm$ 0.010	0.135 0.115	.124	
5	Handle Tube	0.090Inches $\pm$ 0.010	0.100 0.080	.084	
6	Handle Tube	45.000Degrees $\pm$ 0.000	45.000 45.000	45	Angle
7	Handle Tube	0.350Inches + 0.010 - 0.000	0.360 0.350		Radius .354
8	Handle Tube	0.158Inches $\pm$ 0.010	0.168 0.148	.154	
9	Handle Tube	0.386Inches + 0.005 - 0.000	0.391 0.386		Diameter .388
10	Handle Tube	0.700Inches $\pm$ 0.010	0.710 0.690		Diameter .7

Plex 2/1/19 8:09 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					